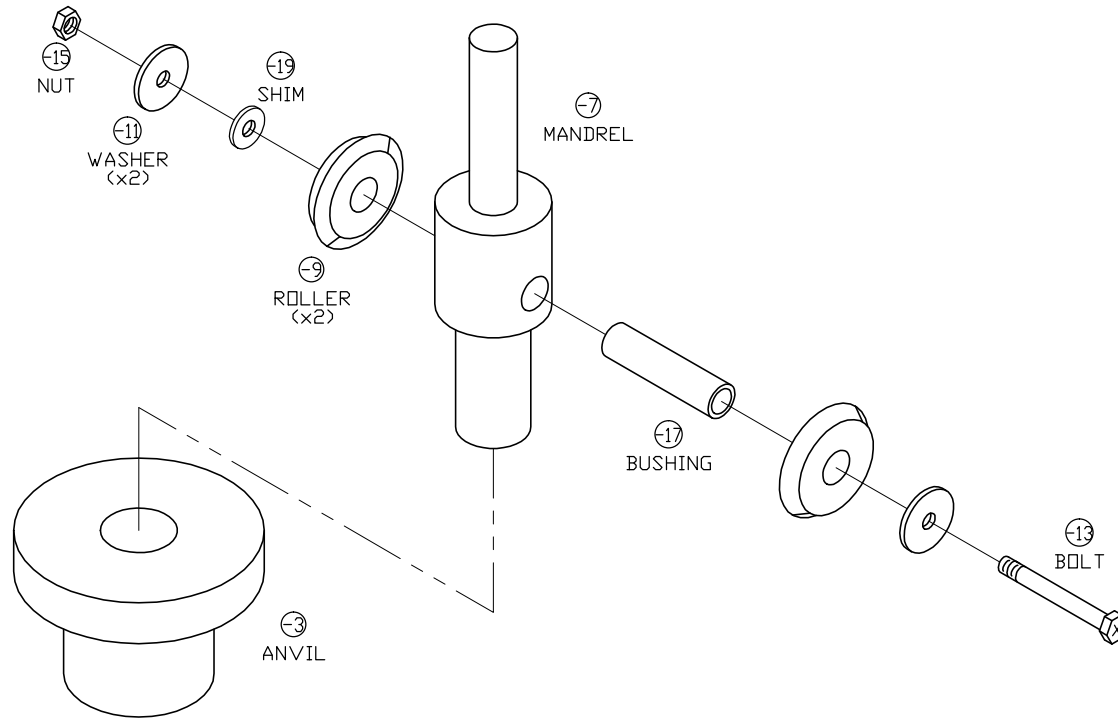


This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D -11 FROM WASHER - AN970-3.	8/11/16	WP	
2	CH'D -11 HOLE DIA. TO .188, CH'D DWG. NO. TO RB T101584, DELETED -5 NON-ASSOCIATIVE FROM BOM, CH'D -17 & -19 INFO ON BOM.	5/12/09	RJC	
3	ADDED -5 ASSEMBLY PER E.B. CH'D -17 OVERALL LENGTH FROM 1.680 +.007-.000 & RC 48-52 PER D.W. ADDED -21, ADDED NOTE 1 FOR -19 & -21 PER R.W.	9/23/11	RJC	

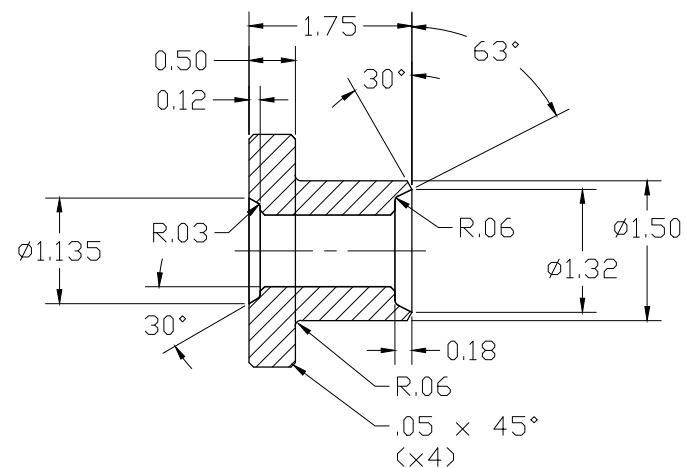
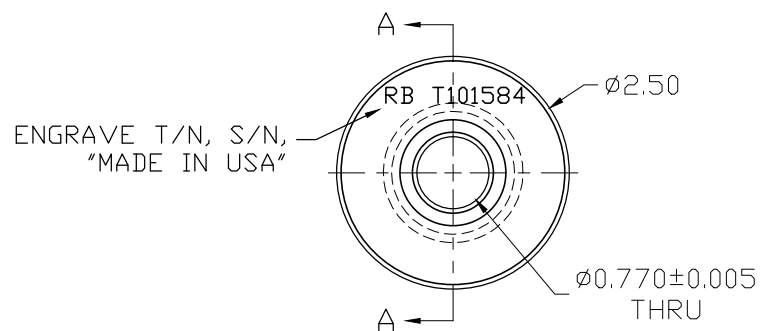


ASSY QTY	ASSY QTY	B/D	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/D INFORMATION OR SPECIFICATIONS	Pg.
			-3	1	ANVIL	4140	ø2-1/2 x 1-7/8	2
			-5	1	ROLL STAKING TOOL ASSY.			3
1			-7		MANDREL	4140	ø1-1/4 x 4-7/8	4
2			-9		ROLLER	DHTS	ø1-1/2 x 3/4	5
2			-11		WASHER	4140 Q&T	ø3/4 x 3/16	6
1	B/D		-13		BOLT	STEEL	#AN3-20A	1
1	B/D		-15		NUT	STEEL	#MS21042	1
1			-17		BUSHING	01	ø7/16 x 1-3/4	7
A/R	B/D		-19		SHIM	STEEL	ø.344 O.D. x ø.187 I.D. x .0025 MCMaster-CARR #99040A002	8
A/R	B/D		-21		SHIM	STEEL	ø.308 O.D. x ø.210 I.D. x .0020 MCMaster-CARR #Z9883-20	9
ASSY	-5							

RED BARN MACHINE	
TITLE ROLL STAKING TOOL	
DWG NO. RB T101584	REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	METRIC REF. .XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-6-00
SHEET 1 of 9	


This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

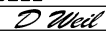
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



SECTION A-A

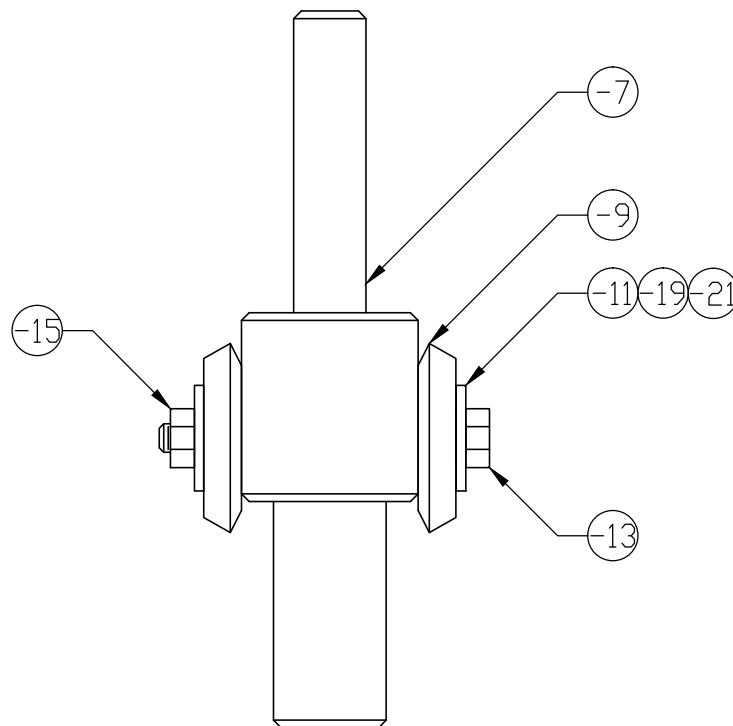
③
ANVIL

 RED BARN MACHINE	
TITLE ROLL STAKING TOOL	
DWG NO. RB T101584-3	REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
METRIC REF. .XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± .5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-6-00
SHEET 2 of 9	

DRAWN BY: COLE
APPROVED 
HEAT RC 25-32
FINISH CAD YELLOW
SPEC QQ-P-416F, TYPE II, CLASS II
USED ON MODEL BELL 206, TH-57A

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
3	ADDED -5 ASSEMBLY PER E.B.	9/23/11	RJC	

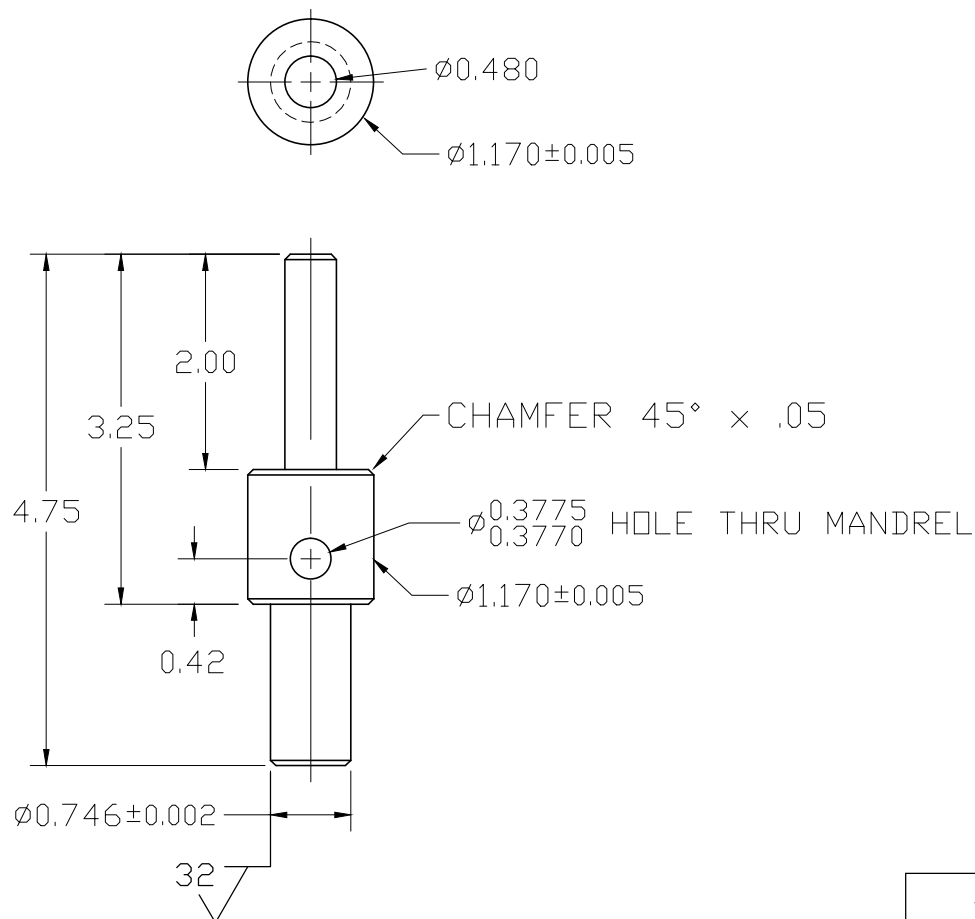


(-5)
ROLL STAKING TOOL
ASSEMBLY

RB RED BARN MACHINE	
TITLE ROLL STAKING TOOL	
DWG NO. RB T101584-5	REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: COLE APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 206, TH-57A
SCALE NTS	DATE 10-6-00
SHEET 3 of 9	

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED

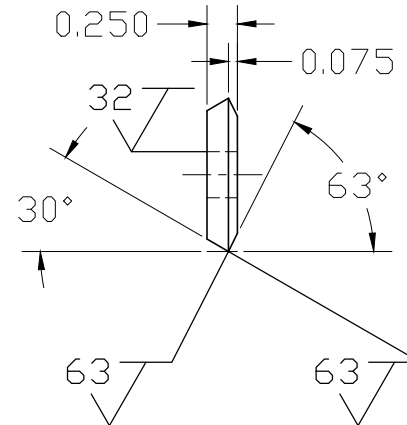
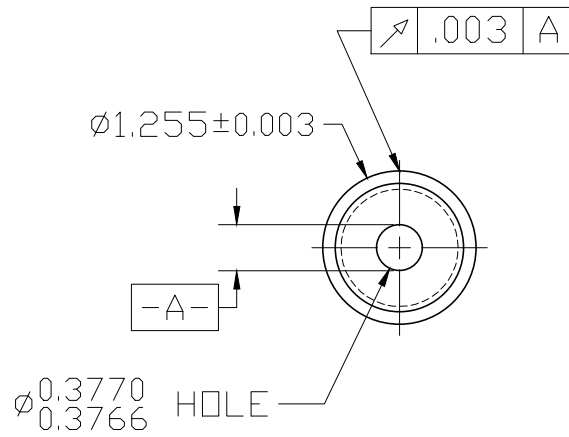


(-7)
MANDREL

RED BARN MACHINE			
TITLE ROLL STAKING TOOL			
DWG NO. RB T101584-7			REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: COLE	
TOLERANCES ON:		APPROVED <i>D Weil</i>	
DECIMALS .XXX ± .005		HEAT RC 25-32	
.XX ± .01		FINISH CAD YELLOW	
.X ± .1		SPEC QQ-P-416F, TYPE II, CLASS II	
ANGLES ± 5°		USED ON MODEL	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R		BELL 206, TH-57A	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SHEET 4 of 9	
SCALE	NTS	DATE	10-6-00

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



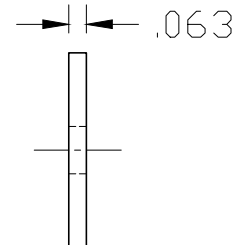
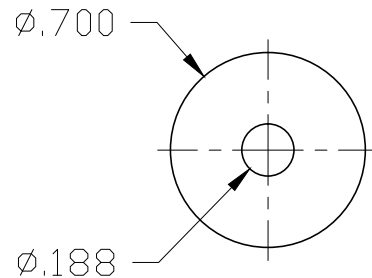
(-9)

ROLLER

RED BARN MACHINE	
TITLE ROLL STAKING TOOL	
DWG NO. RB T101584-9	REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX $\pm .005$.XX $\pm .01$.X $\pm .1$	DRAWN BY: COLE APPROVED: <i>D. Weil</i> HEAT TREAT: RC 55-60 FINISH: BLACK OXIDE SPEC: UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE NTS	DATE 10-6-00
SHEET 5 of 9	

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
2	CH'D -11 HOLE DIA. TO .188.	5/12/09	RJC



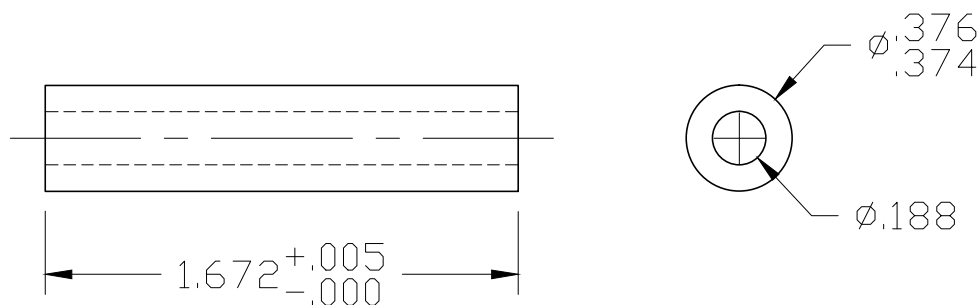
-11

WASHER

RB RED BARN MACHINE			
TITLE ROLL STAKING TOOL			
DWG NO. RB T101584-11		REV 3	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: COLE	
TOLERANCES ON:		APPROVED <i>D Weil</i>	
DECIMALS		HEAT	
.XXX \pm .005		TREAT	
.XX \pm .01		FINISH CAD YELLOW	
.X \pm .1		SPEC QQ-P-416F, TYPE II, CLASS II	
UNLESS OTHERWISE SPECIFIED		USED ON MODEL	
1. BREAK ALL SHARP EDGES		BELL 206, TH-57A	
.015 \times 45° PR .015 R		SCALE NTS	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		DATE 10-6-00	
		SHEET 6 of 9	

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION		DATE	INITIAL
3	CH'D -17 OVERALL LENGTH FROM 1.680 +.007-.000 & RC 48-52 PER D.W.		9/23/11	RJC

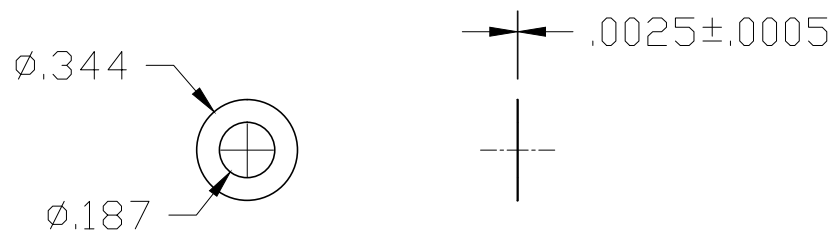


(-17)
BUSHING

RED BARN MACHINE			
TITLE ROLL STAKING TOOL			
DWG NO. RB T101584-17			REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: COLE	
TOLERANCES ON:		APPROVED <i>D Weil</i>	
DECIMALS .XXX ± .005		HEAT RC 48-52	
.XX ± .01		FINISH BLACK OXIDE	
.X ± .1		SPEC	
FRACTIONS ± 1/32		USED ON MODEL	
ANGLES ± 5°		BELL 206, TH-57A	
UNLESS OTHERWISE SPECIFIED		DATE 10-6-00	
1. BREAK ALL SHARP EDGES		SHEET 7 of 9	
.015 x 45° PR .015 R			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE NTS			

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
3	ADDED NOTE 1 PER R.W.	9/23/11	RJC	



①-19

SHIM

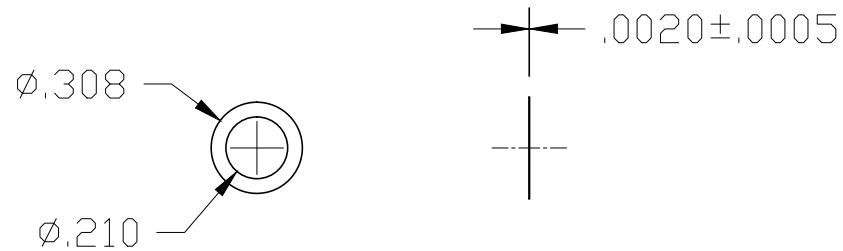
NOTES

1. FOR REFERENCE ONLY, B/O SHIM SPECS.

RED BARN MACHINE	
TITLE ROLL STAKING TOOL	
DWG NO. RB T101584-19	REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: COLE
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	APPROVED <i>D Weil</i>
METRIC REF. .XXmm ± .1mm	HEAT TREAT
FRACTIONS ± 1/32	FINISH
ANGLES ± .5°	SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 206, TH-57A
SCALE NTS	DATE 10-6-00
	SHEET 8 of 9

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
3	ADDED -21, ADDED NOTE 1 PER R.W.	9/23/11	RJC	



②1
SHIM

NOTES

1. FOR REFERENCE ONLY, B/O SHIM SPECS.

RB RED BARN MACHINE	
TITLE ROLL STAKING TOOL	
DWG NO. RB T101584-21	REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: COLE
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	APPROVED <i>D Weil</i>
METRIC REF. .XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°	HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 206, TH-57A
SCALE NTS	DATE 10-6-00
SHEET 9 of 9	